

Date: Wednesday, 11/22/2006 1:39:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 29647B	Part Number	: D32782
Estimate Number	: 10462	Drawing Number	: D3278 REV. B
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 11/22/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Due Date	: 11/29/2006
Previous Run	: 29236B	Qty:	<i>split</i> Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 061122		
Comment	: Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: *M19295**mk 07/01/08**(52)*

2.0	SHEAR <i>SAW</i>	SHEAR
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Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

*mk 07/01/08**(52)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

*JH/J.F. 07/01/10**30*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JH/J.F. 07/01/10**30*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*MS 07/01/11**30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/11	3	- 2 parts are scrapped - dimension .119 $\pm .005$ under tolerance		- scrap & replace	J.L. 07/01/11	MA 07/01/11		MA 07/01/11

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 29647B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*JS/am*

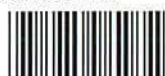
*07-01-12*

*(30)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*SL/YL*

*07/01/16*

*(30)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*SL/YL 07/01/16 (30)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *514/18*

*EP 04/01/16 (30)*

*07/01/16*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*C20710117*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	29647B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.100"	✓			
0.359	+/-0.005	.359"	✓			
0.615	+/-0.010	.615"	✓			
0.250	+/-0.010	.249"	✓			
1.480	+/-0.005	1.485"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.120"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.982"	✓			
R0.130	+/-0.010	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø.261"	✓			
R0.375	+/-0.010	R.375"	✓			
0.875	+/-0.010	.877"	✓			
0.500	+/-0.010	.500"	✓			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.722"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.125	+/-0.010	.128"	✓			

Measured by: J.F.	Audited by: E	Prototype Approval:	N/A
Date: 07/01/09	Date: 07/01/09	Date:	N/A

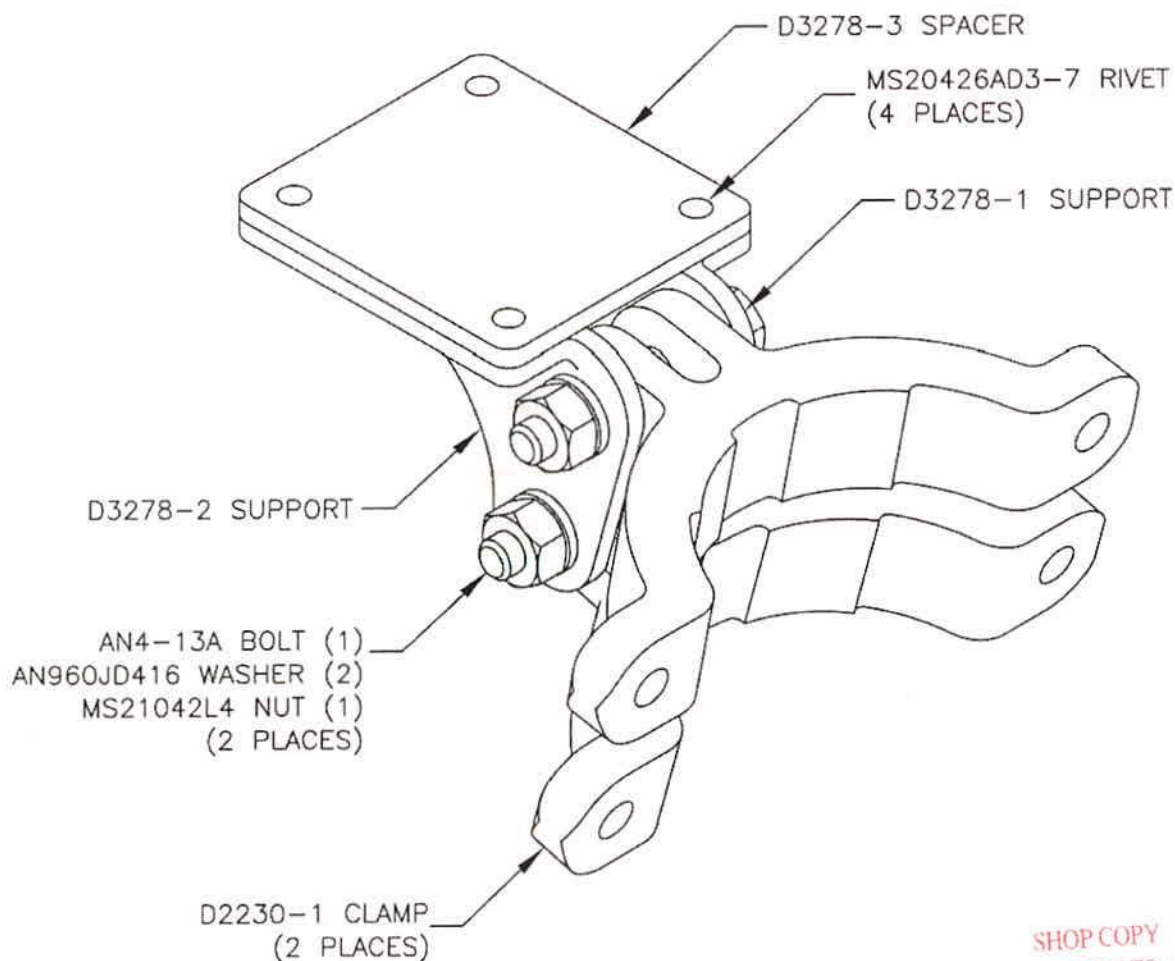
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

**DART**

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31		TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03		NEW ISSUE		
B	05.03.31		CHANGE DIM/TOL TO ENSURE FIT		

**RELEASED**  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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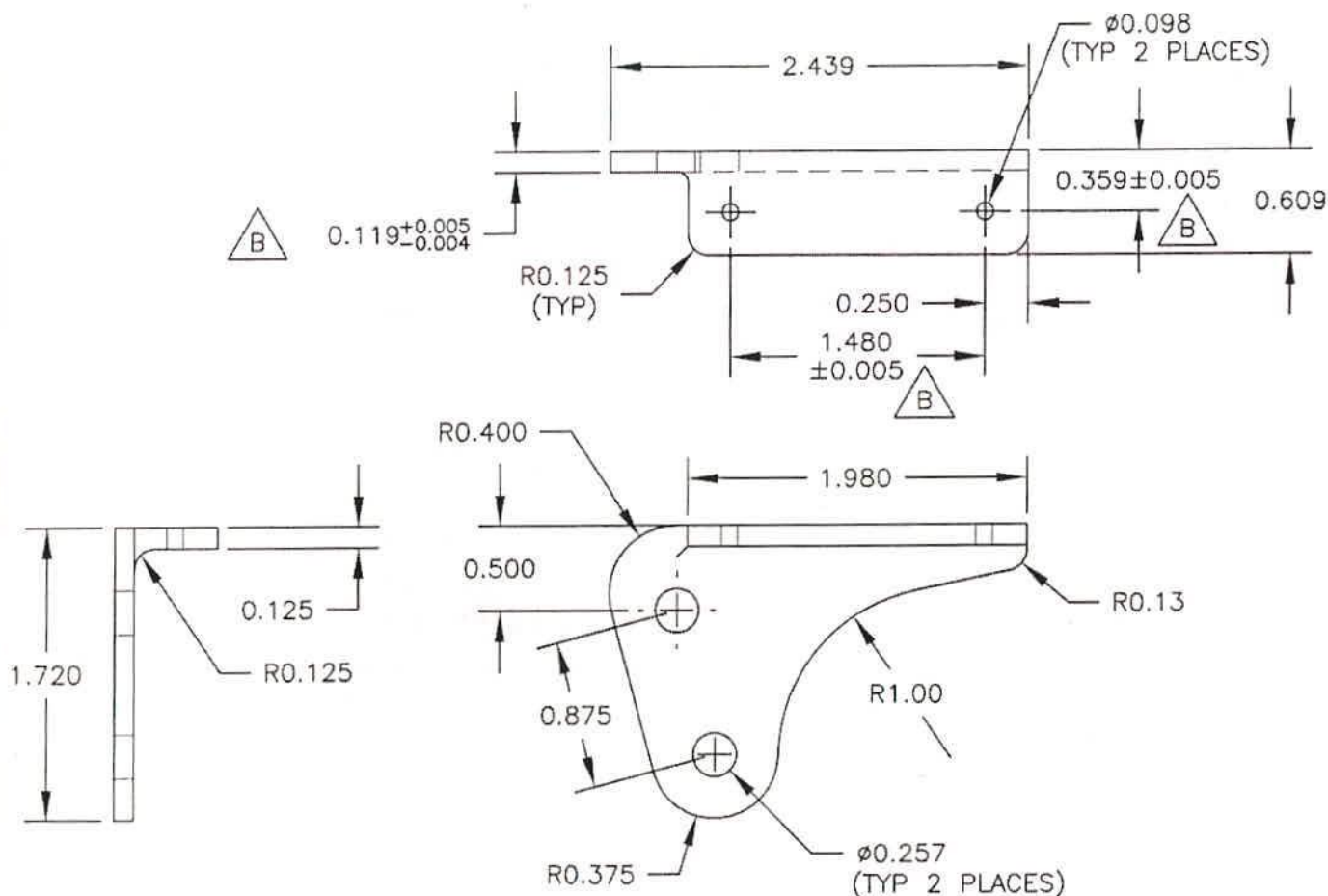
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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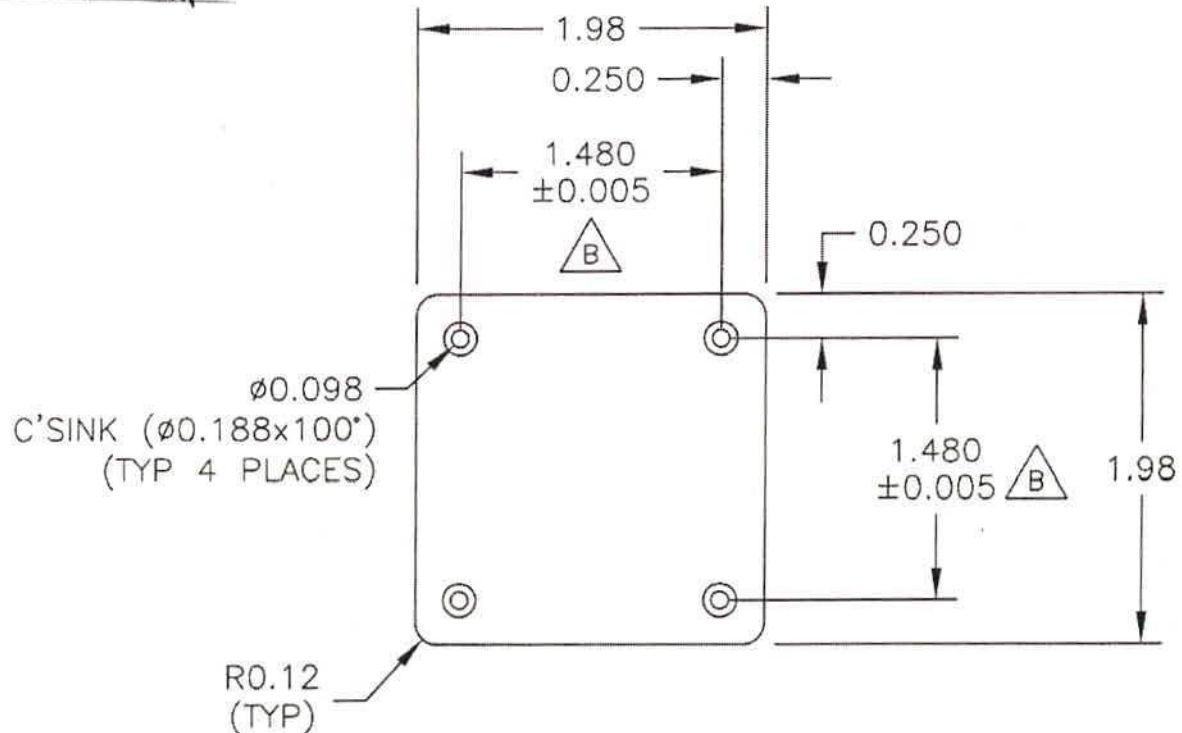
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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